

Date: Monday, 5/1/2006 8:41:43 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT TUBE ASSEMBLY
Job Number :	26893		
Estimate Number :	10699		
P.O. Number :	N/A	Part Number :	D3391025
This Issue :	5/1/2006	Drawing Number :	D3391 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	D
Previous Run :	26892	Material :	N/A
Written By :	SEE COMMENT BELOW	Due Date :	5/20/2006
Checked & Approved By :	SEE ABOVE USER & DATE	Qty:	1 Um: Each
Comment :	Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
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Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)
 ALUMINUM EXTRUSION

Pick:

Qty: Part Number Description Batch

1 D6014-090 Extrusion 24315B

Identify as D3391-3 → D6014-104

M8 06/05/01 1

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: D

M8 06/05/01 1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/05/01 1

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: D

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803;

3-Deburr

M8 06/05/01 1

W/O		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 8:41:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26893

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mt 06/05/10 1

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/05/10 1

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 06-5-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-10 ①

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

BE 06-05-19 ①

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-23 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 06/05/23 ①

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26893

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/23 ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

M17905

15.0

NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

M100732

16.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

or NAS1330C3KB266

M17905

17.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB316 Insert

or NAS1330C3KB316

M17905

DL 06/05/23 ①

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 8:41:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26893

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B25381

B25381

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	M100651

M100651

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	M18822

M18822

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	M100186

M100186

DL 06/05/23 ①

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

DL 06/05/23 ①

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

M100901

Sikaflex expiry date:

11/06

DL 06/05/23

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: P Date: 06/05/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 26893

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Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 160523 (1)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *N/A*

Handwritten: DL 06/05/24 (1)

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: 06/05/24 (2)

Job Completion



Handwritten: U 26.0529

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26893
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.496	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.195	✓			
1.526	+0.000/-0.030	1.522	—			
0.200	+/-0.010	0.197	—			
7.500	+/-0.010	7.496	—			
27.750	+/-0.010	27.750	—			
31.750	+/-0.010	31.750	—			
35.250	+/-0.010	35.250	—			
0.400	+/-0.010	0.399	—			
N/A Ø0.208	+0.005/-0.001					
3.300	+/-0.010	3.296	—			
0.200	+/-0.010	0.196	—			
3.520	+/-0.010	3.526	—			
0.687	+0.010/-0.000	0.688	—			
R0.062	+/-0.010	R0.062	—			
Ø0.484	+0.005/-0.001	Ø0.486	—			

Measured by: MS / gmk	Audited by: En	Prototype Approval:	N/A
Date: 06/05/10	Date: 06/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue	KJ/JLM	